

Date: Tuesday, 11/14/2006 10:13:27 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 29449		
Estimate Number	: 12589		
P.O. Number	: <i>N/A</i>	Part Number	: D35603
This Issue	: 11/14/2006 S.O. No. <i>N/A</i>	Drawing Number	: D3560 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL / MED FAB	Drawing Revision	: A
Previous Run	: <i>N/A</i>	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 11/25/2006
Checked & Approved By	: <i>[Signature]</i> 06-11-14	Qty:	5 Um: Each
Comment	: Est Rev:A New Issue 06-11-10 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.0080 f(s)/Unit Total: 5.0400 f(s)

6061-T6 Bar .50" x 6.0"

Batch: *M101919 ml 06-11-20*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3560

Dwg Rev: *A*Prog Rev: *A**ml 06-11-21**(5)*

2-Deburr if necessary

Note: .507" Dia & .196" Dia Holes are to opened on manual mill after Waterjet

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

*(5)*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

1-Open .196" Dia hole

2-C'Bore as per Dwg D3560.

3-Ream .507" as per Dwg D3560

Ensure to C'Bore on Corect side

*J.F. 06/12/19**(5)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/12/20

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 29449

Part Number: D35603

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/12/19 (5)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/21/9x5

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

06/12/20 (5)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/20 (5)

Job Completion



C Loc 11/21/20

Dart Aerospace Ltd

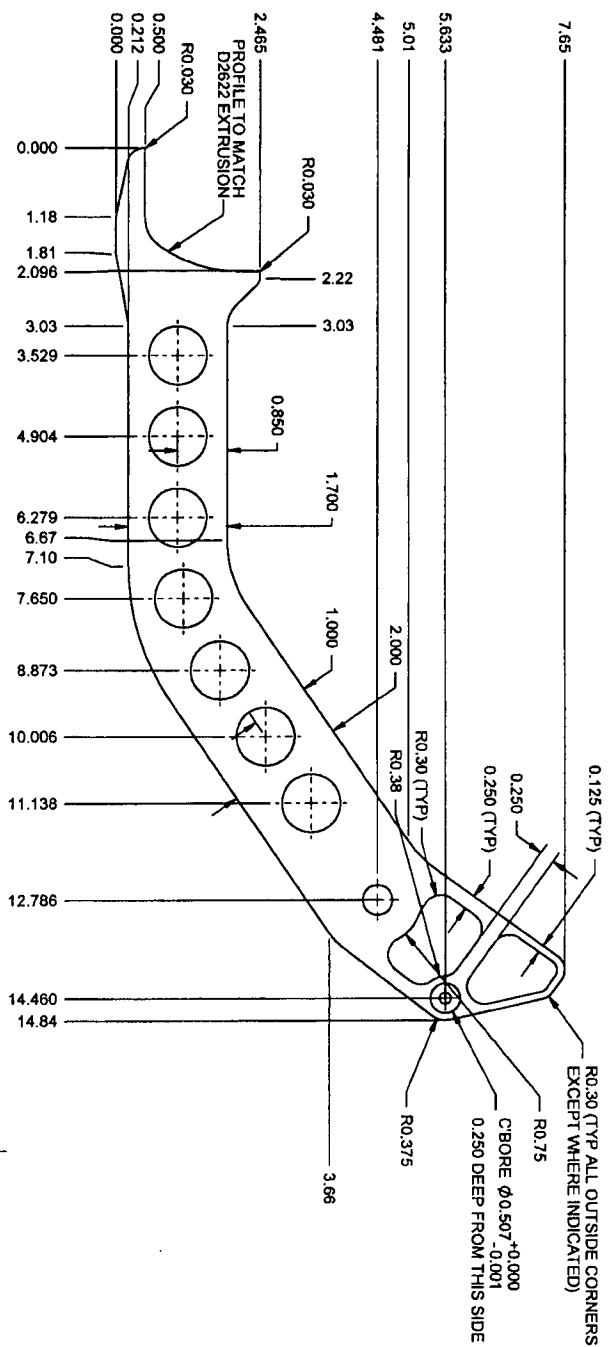
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

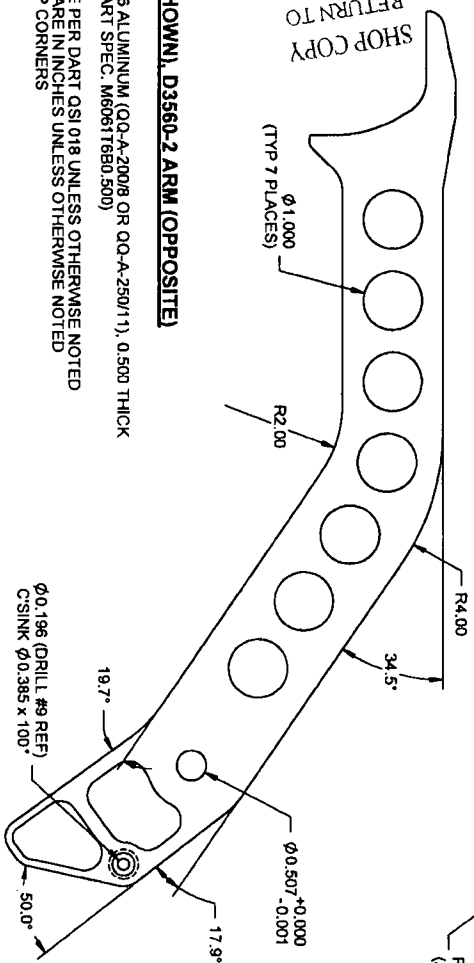
NOTE: Date & initial all entries



NO. 29449
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)

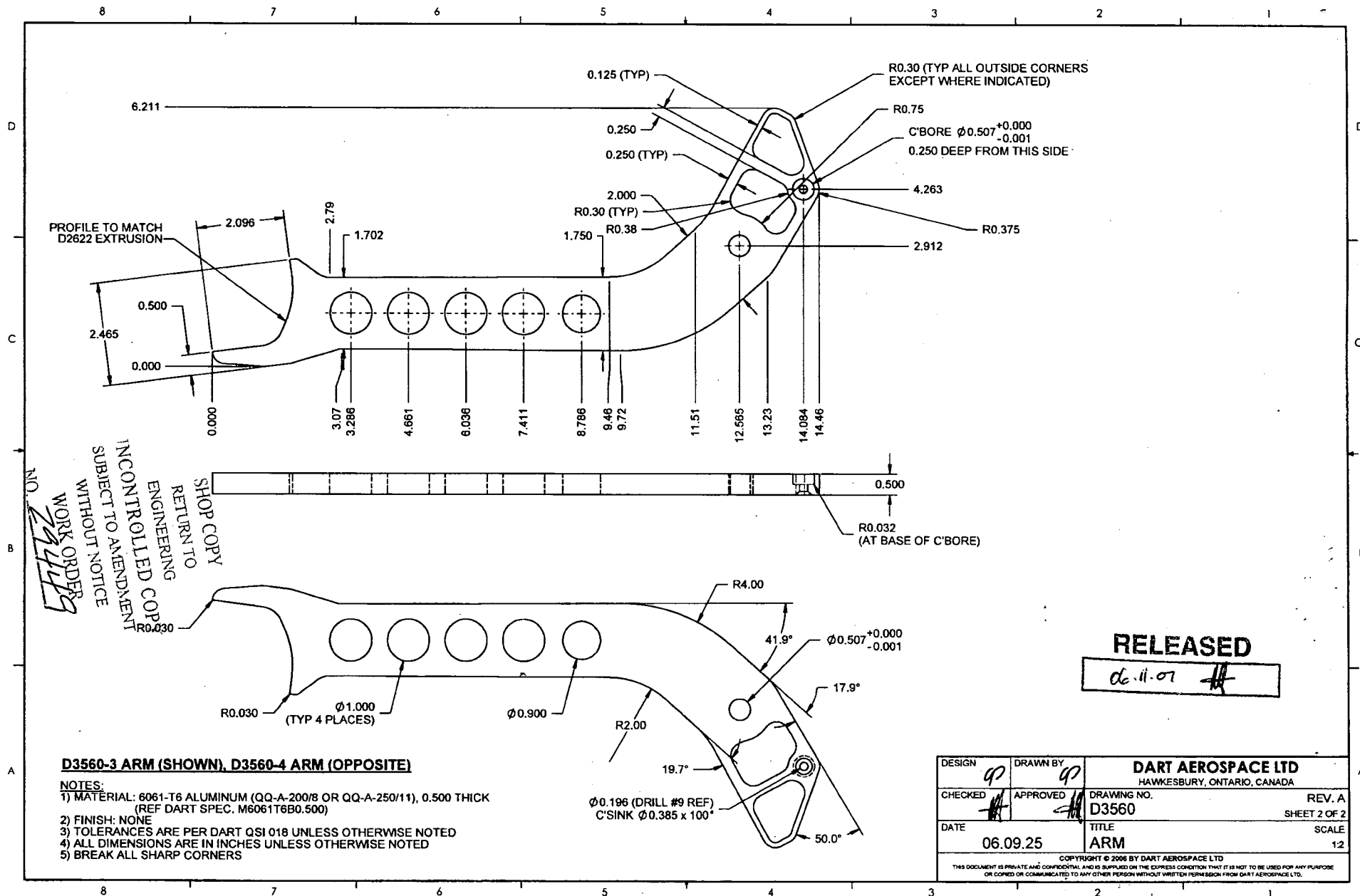
- NOTES:
1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-2008 OR QQ-A-250/11), 0.503 THICK
(REF DART SPEC. M6061T6B0.503)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QS 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP CORNERS



A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY <i>qq</i>	DART AEROSPACE LTD HAWESBURY, ONTARIO, CANADA
CHECKED <i>qq</i>	APPROVED <i>qq</i>	DRAWING NO. RD3560
DATE	06.09.25	TITLE ARM
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RELEASED

06:11:07



RELEASED

06.11.07

DESIGN	90	DRAWN BY	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	APPROVED	90	DRAWING NO. D3560	REV. A
DATE	06.09.25	TITLE	ARM	SHEET 2 OF 2	
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DART AEROSPACE LTD	Work Order: 29449
Description: ARM	Part Number: D3560-3
Inspection Dwg: D3560-1 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000 - 0.001	0.506	✓		VERN	
Ø0.196	+0.005 - 0.001	0.196	✓		VERN	
Ø0.900	+0.010 - 0.001	0.900	✓		VERN	
Ø1.000	+0.010 - 0.001	1.000	✓		VERN	
1.750	+/- 0.010	1.751	✓		VERN	
1.702	+/- 0.010	1.705	✓		VERN	
2.465	+/- 0.010	2.464	✓		VERN	
2.000	+/- 0.010	2.003	✓		VERN	
0.250	+/- 0.010	0.253	✓		VERN	
0.250	+/- 0.010	0.253	✓		VERN	
0.125	+/- 0.010	0.128	✓		VERN	
0.500	+/- 0.010	0.500	✓		VERN	
385x100°	± .010"	385x100°	✓			
507x250 deep	± .010"	250"	✓			

Measured by: M. M. S.	Audited by: En	Prototype Approval: N/A
Date: 06/11/21	Date: 06/12/19	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	